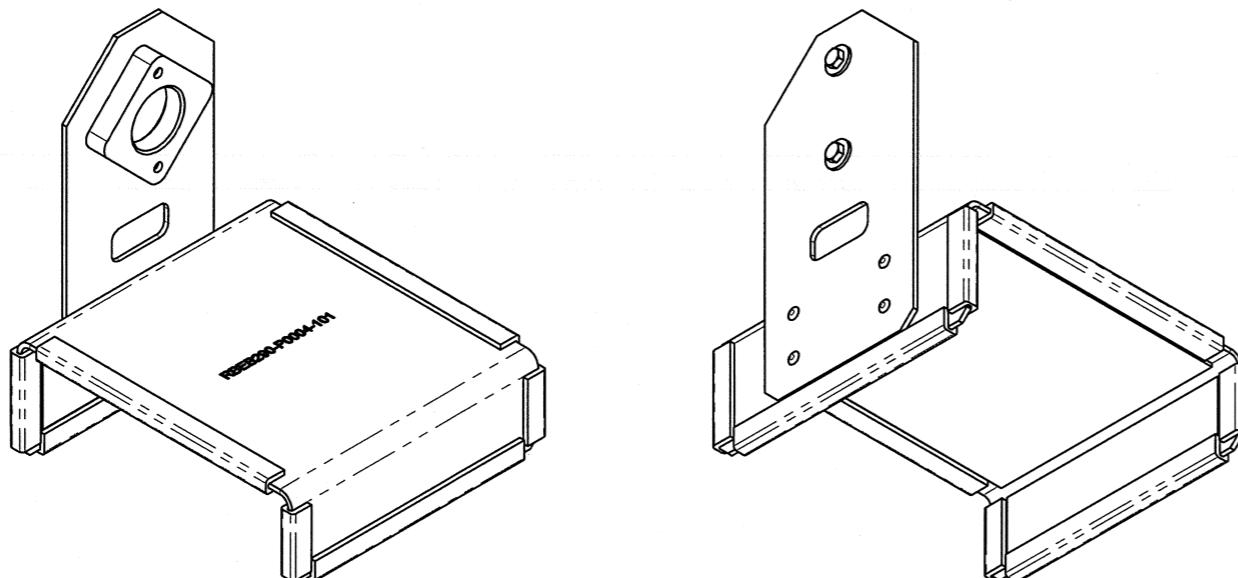


ITEM #	QTY	PART #	PART TITLE
-1	1	RBEB290-P0004-101-1	BASE
-3	1	RBEB290-P0004-101-3	PLATE
-7	1	RBEB290-P0004-101-7	CENTER PAD
-9	1	RBEB290-P0004-101-9	BACK PAD
-11	1	RBEB290-P0004-101-11	FRONT PAD
-12	1	RBEB290-P0004-101-12	ADAPTER ASSEMBLY
13	8	McMaster#24175K46 OR EQUIV.	RUBBER U-CHANNEL PUSH-ON TRIM 31/64" INSIDE HT. X 1/8" INSIDE WD.
14	2	McMaster#93635A208 OR EQUIV.	316 SS HEX HEAD SCREW M6 X 1 mm X 12 mm LG.
15	2	McMaster#95211A160 OR EQUIV.	316 SS WASHER 6.4 mm ID. X 18.0 mm OD. X 1.4-1.8 mm THK.
16	4	MS20470AD5-6	RIVET



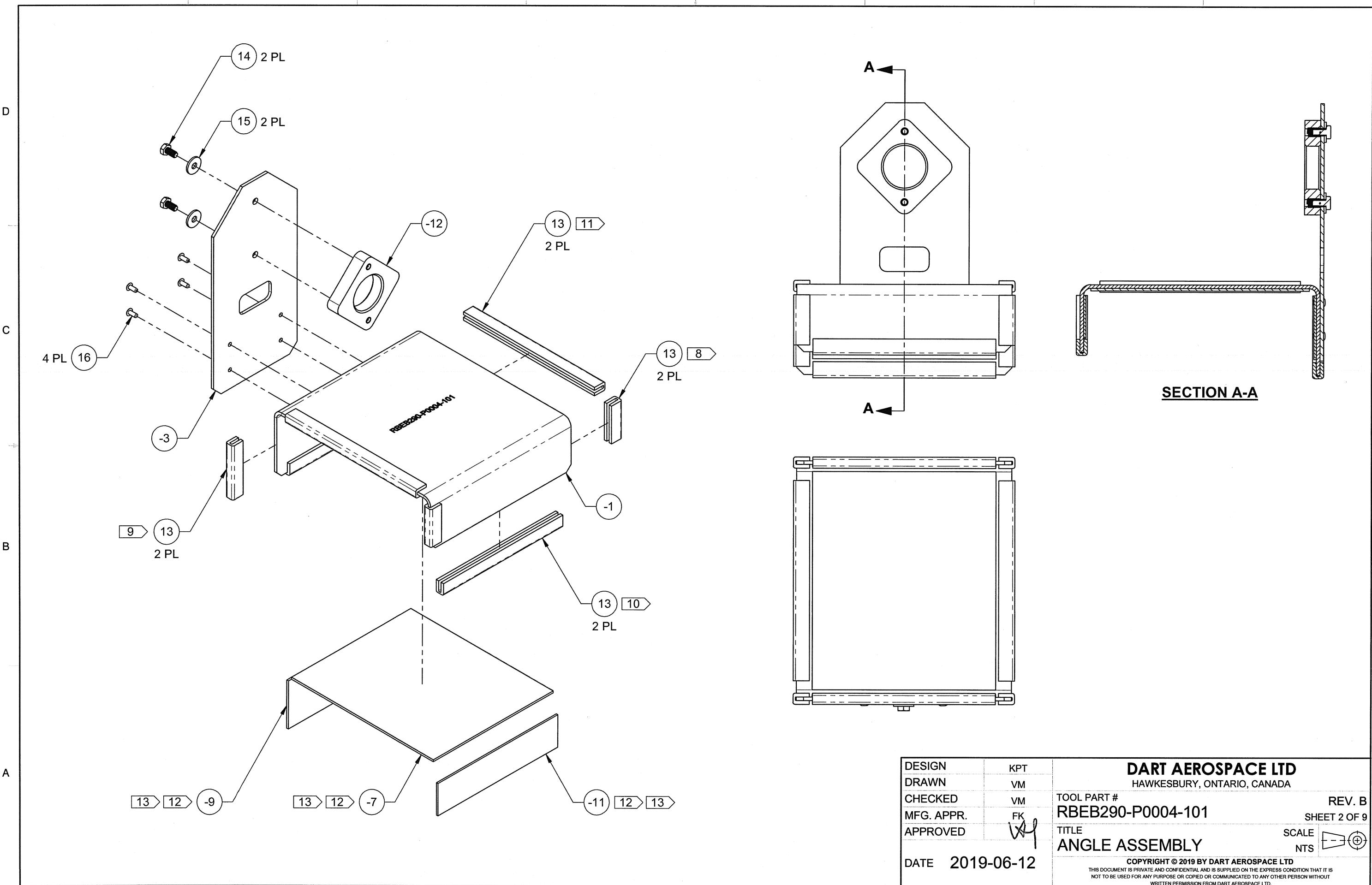
RBEB290-P0004-101 ANGLE ASSEMBLY

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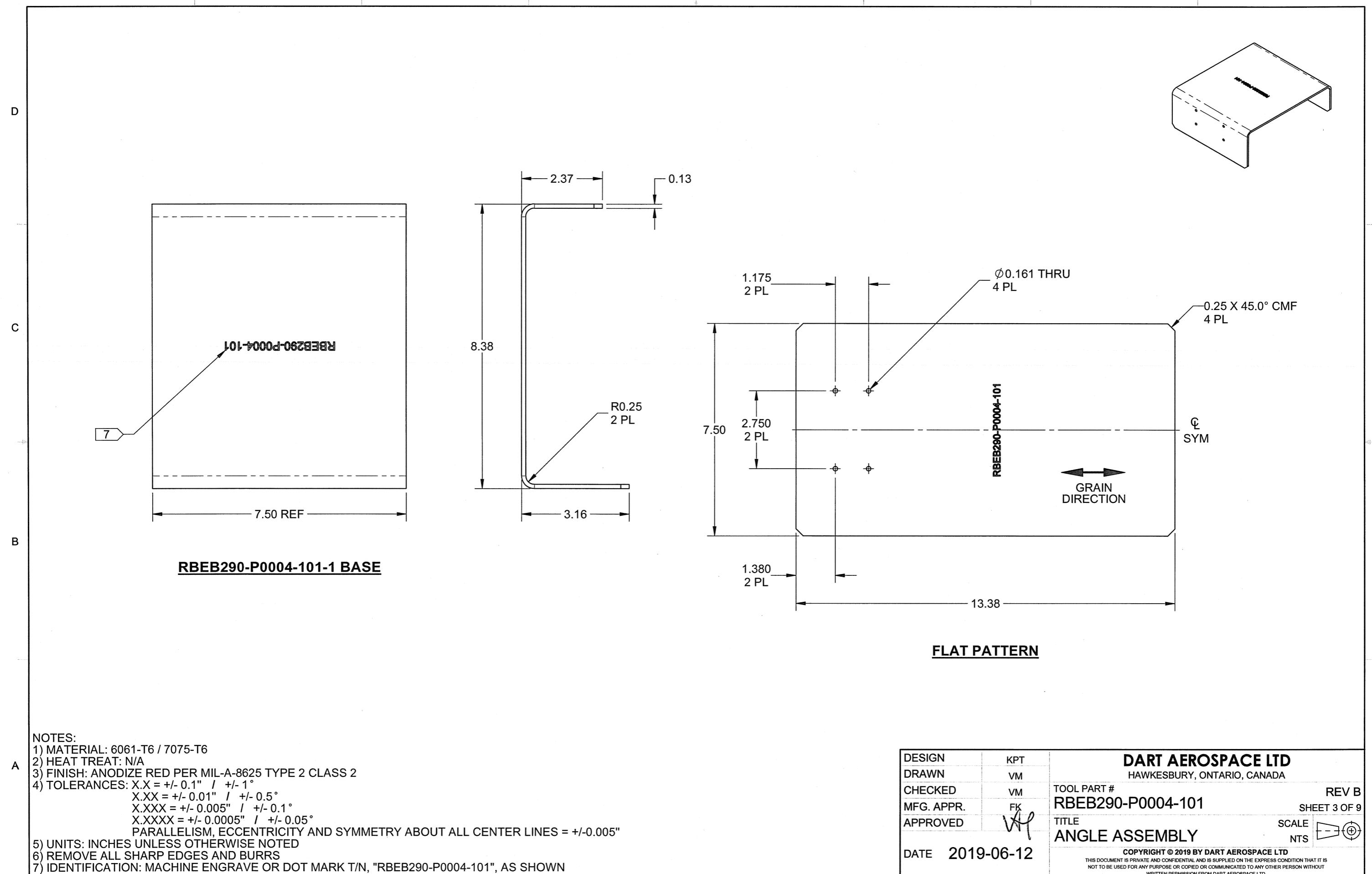
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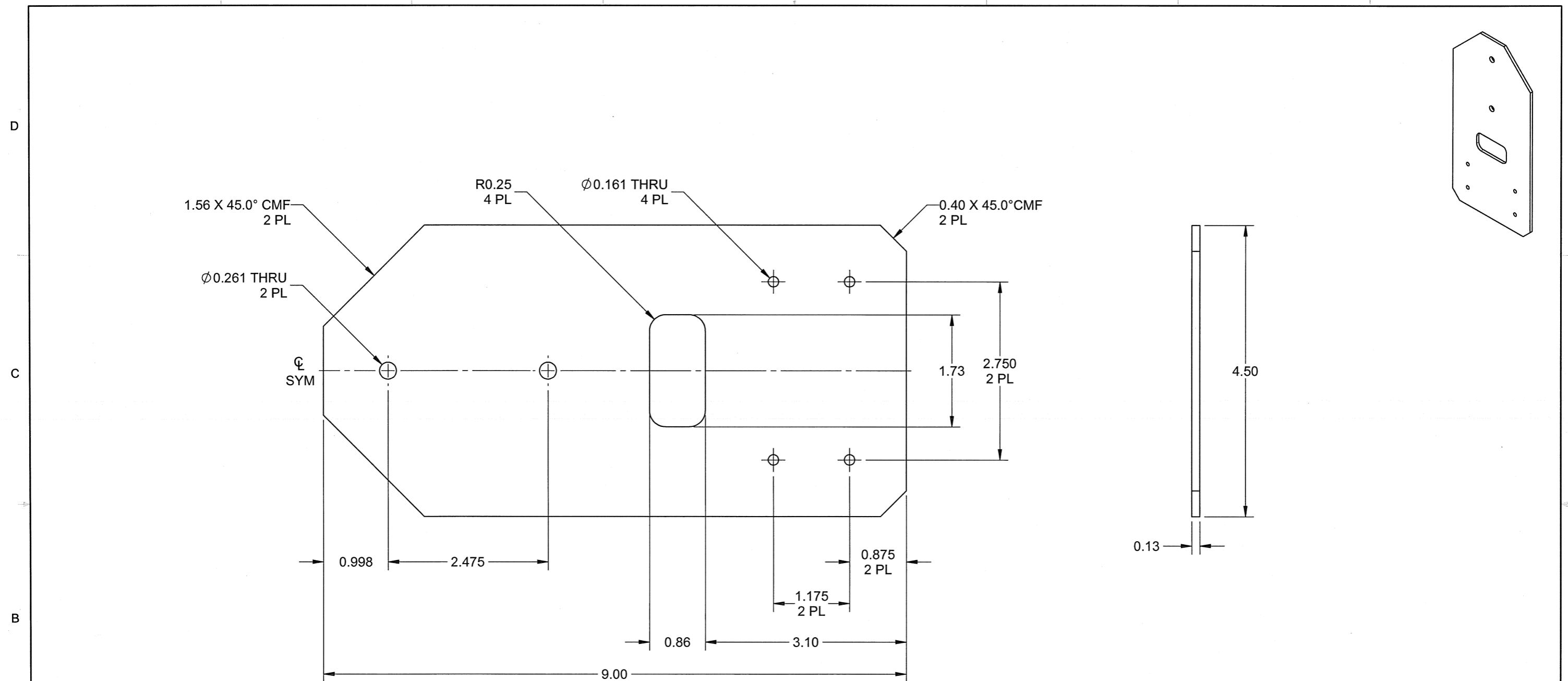
- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
X.XX = +/- 0.01" / +/- 0.5°
X.XXX = +/- 0.005" / +/- 0.1°
X.XXXX = +/- 0.0005" / +/- 0.05°
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/-0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) IDENTIFICATION: N/A
- 7) ASSEMBLE AS SHOWN
- 8) CUT TO 1.75" LENGTH THEN ASSEMBLE WITH ITEM -1 AS SHOWN
- 9) CUT TO 2.50" LENGTH THEN ASSEMBLE WITH ITEM -1 AS SHOWN
- 10) CUT TO 6.38" LENGTH THEN ASSEMBLE WITH ITEM -1 AS SHOWN
- 11) CUT TO 7.00" LENGTH THEN ASSEMBLE WITH ITEM -1 AS SHOWN
- 12) ASSEMBLE ITEMS -7, -9, AND -11 ADHESIVE SIDE ON ITEM -1 AS SHOWN, AND CUT EXCESS IF NECESSARY
- 13) APPLY INSTANT ADHESIVE LOCTITE 495 BETWEEN THE SURFACES
OF ITEMS -7, -9, AND-11, AND ITEM -1 IF NECESSARY, AND REMOVE EXCESS
- 14) THE TOOL ASSY MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG

B	T/N WAS RBEB290-P0001-101 ALIGMENT TOOL IS RBEB290-P0004-101 ANGLE ASSEMBLY 19-770	VM	
A	SEE PREVIOUS REVISION FOR MORE INFORMATION UPDATED DRAWING TEMPLATE ADDED ITEMS -12 AND 15 ADDED DRAWINGS FOR ITEMS -7, -9, -11, AND -12 ITEM 13 WAS MCMASTER-CARR #8672K41 IS McMaster#24175K46 ITEM 14 WAS MCMASTER-CARR #91280A324 IS McMaster#93635A208 ITEM 16 WAS MCMASTER-CARR #97484A243 IS MS20470AD5-6 -1 ADDED FLAT PATTERN. MATERIAL WAS 5052 IS 6061-T6 / 7075-T6. FINISH WAS PAINT TEMPO GREEN IS ANODIZE RED. DIM WAS Ø .188 (x4) IS Ø 0.161 THRU 4 PL. DIM WAS 1.187 (x2) IS 1.175 2 PL. DIM WAS 3.125 IS 3.16. DIM WAS .120 IS 0.13. DIM WAS R.019 (x2) IS R0.252 PL. DIM WAS 8.43 IS 8.38. REMOVED 1.375, 3.75, .72 (x2) DIMS -3 MATERIAL WAS 6061 IS 6061-T6 / 7075-T6. FINISH WAS PAINT TEMPO GREEN IS ANODIZE RED. DIM WAS .44x45° (x2) IS 0.40 X 45.0° CMF 2 PL. DIM WAS 1.1875 (x2) IS 1.175 2 PL. DIM WAS 2.670 IS 2.475. DIM WAS 1.63x45° (x2) IS 1.56 X 45.0° 2 PL. DIM WAS .12 IS 0.13. DIM WAS R.187 (x4) IS R0.25 4 PL. DIM WAS Ø .188 (x8) IS Ø 0.161 THRU 4 PL. REMOVED 1.375, 2.477 (x2), .56, .75, 4.50, 2.25 DIMS. ADDED Ø 0.261 THRU 2 PL, 0.998, 3.10, 0.875 2 PL DIMS -5 MATERIAL WAS 6061 IS 6061-T6 / 7075-T6. FINISH WAS CLEAR ANODIZE IS ANODIZE RED. DIM WAS 2.50 IS 2.52. DIM WAS M6x1 (x2) IS TAP FOR M6 X 1.0 HELICOIL INSERT THRU 2 PL. DIM WAS 0.547 IS 0.56. REMOVED 2.50, .944 (x2), REF. (x2) B.C. Ø 2.670 @ 45°, .06x45° DIMS. ADDED R0.31 4 PL, 2.475 DIMS	KPT	
REV.	DESCRIPTION	ECN #	BY
DESIGN	KPT	DART AEROSPACE LTD	
DRAWN	VM	HAWKESBURY, ONTARIO, CANADA	
CHECKED	VM	REV B	
MFG. APPR.	FK	TOOL PART #	
APPROVED	VJ	RBEB290-P0004-101	
DATE 2019-06-12		TITLE ANGLE ASSEMBLY	
SCALES NTS			
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DESIGN DRAWN	KPT VM	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED VM		
MFG. APPR. FK		
APPROVED		
DATE 2019-06-12		REV. B SHEET 2 OF 9
TOOL PART # RBE290-P004-101		SCALE NTS
TITLE ANGLE ASSEMBLY		
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RBE290-P0004-101-3 PLATE

NOTES:

- 1) MATERIAL: 6061-T6 / 7075-T6
- 2) HEAT TREAT: N/A
- 3) FINISH: ANODIZE RED PER MIL-A-8625 TYPE 2 CLASS 2
- 4) TOLERANCES: $X.X = +/- 0.1"$ / $+/- 1^\circ$
 $X.XX = +/- 0.01"$ / $+/- 0.5^\circ$
 $X.XXX = +/- 0.005"$ / $+/- 0.1^\circ$
 $X.XXXX = +/- 0.0005"$ / $+/- 0.05^\circ$
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = $+/- 0.005"$
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: N/A

DESIGN DRAWN	KPT VM	DART AEROSPACE LTD	
CHECKED VM	HAWKESBURY, ONTARIO, CANADA		
MFG. APPR. FK	REV B		
APPROVED <i>W</i>	TOOL PART # RBE290-P0004-101		
	SHEET 4 OF 9		
TITLE ANGLE ASSEMBLY		SCALE NTS	
DATE 2019-06-12		COPYRIGHT © 2019 BY DART AEROSPACE LTD	

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ITEM #	QTY	PART #	PART TITLE
-5	1	RBEB290-P0004-101-5	ADAPTER
17	2	McMaster#91732A782 OR EQUIV.	18-8 SS HELICAL INSERT M6 X 1 mm X 12 mm LG.

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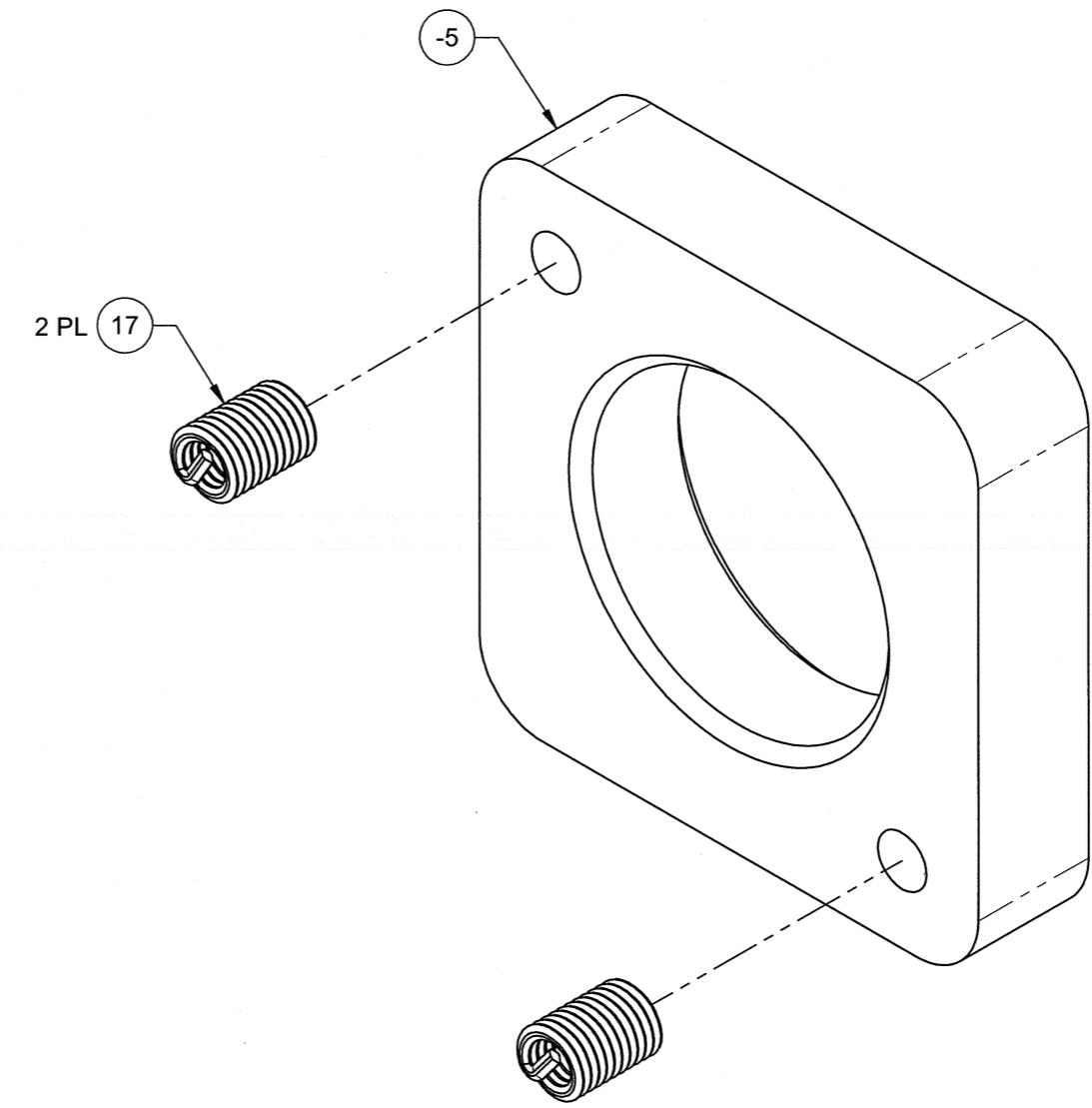
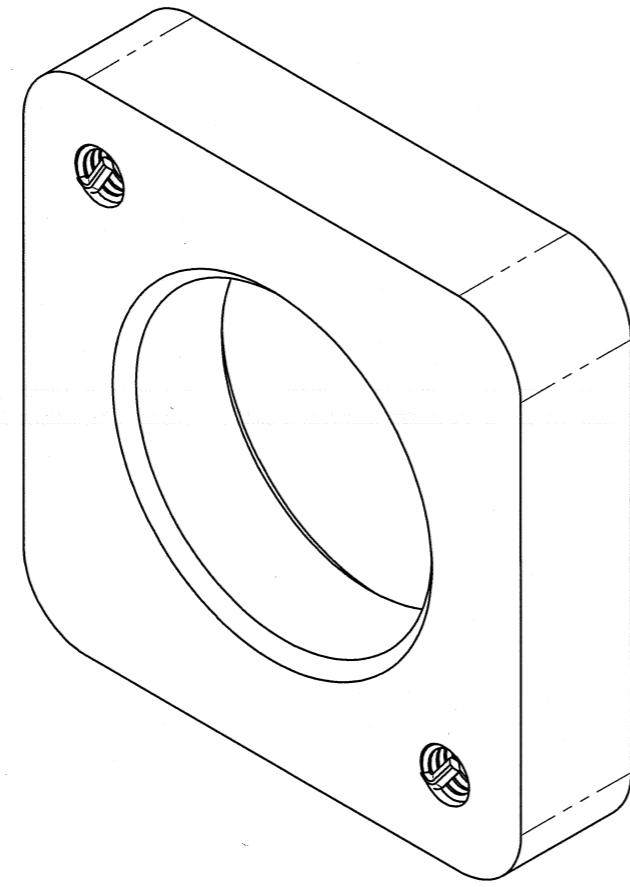
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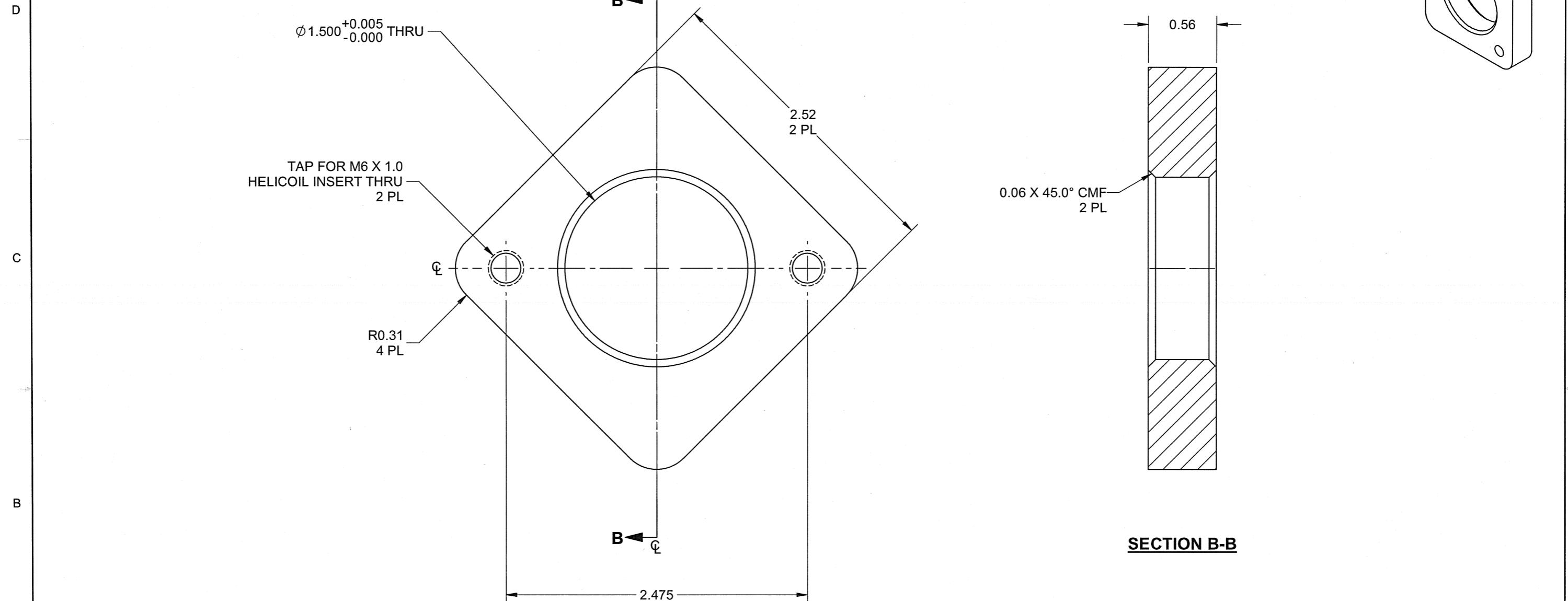
RBEB290-P0004-101-12 ADAPTER ASSEMBLY

NOTES:

- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: $X.X = +/- 0.1"$ / $+/- 1^\circ$
 $X.XX = +/- 0.01"$ / $+/- 0.5^\circ$
 $X.XXX = +/- 0.005"$ / $+/- 0.1^\circ$
 $X.XXXX = +/- 0.0005"$ / $+/- 0.05^\circ$
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = $+/- 0.005"$
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) IDENTIFICATION: N/A
- 7) ASSEMBLE AS SHOWN

DESIGN DRAWN	KPT VM	DART AEROSPACE LTD	
CHECKED	VM	HAWKESBURY, ONTARIO, CANADA	
MFG. APPR.	FK	TOOL PART #	REV. B
APPROVED	WJ	RBEB290-P0004-101	SHEET 5 OF 9
DATE 2019-06-12		TITLE ANGLE ASSEMBLY	
SCALE NTS			

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RBEB290-P0004-101-5 ADAPTER

- NOTES:
- 1) MATERIAL: 6061-T6 / 7075-T6
 - 2) HEAT TREAT: N/A
 - 3) FINISH: ANODIZE RED PER MIL-A-8625 TYPE 2 CLASS 2
 - 4) TOLERANCES: $X.X = +/- 0.1"$ / $+/- 1^\circ$
 $X.XX = +/- 0.01"$ / $+/- 0.5^\circ$
 $X.XXX = +/- 0.005"$ / $+/- 0.1^\circ$
 $X.XXXX = +/- 0.0005"$ / $+/- 0.05^\circ$
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = $+/- 0.005"$
 - 5) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 6) REMOVE ALL SHARP EDGES AND BURRS
 - 7) IDENTIFICATION: N/A

DESIGN	KPT	DART AEROSPACE LTD	
DRAWN	VM	HAWKESBURY, ONTARIO, CANADA	
CHECKED	VM	TOOL PART #	REV B
MFG. APPR.	FK	RBEB290-P0004-101	SHEET 6 OF 9
APPROVED	<i>WJ</i>	TITLE	
		ANGLE ASSEMBLY	
DATE 2019-06-12		SCALE NTS	

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RBEB290-P0004-101-7 CENTER PAD

NOTES:

- 1) MATERIAL: McMaster#8969K654 OR EQUIV. (ULTRA-STRENGTH OIL-RESISTANT BUNA-N RUBBER ADHESIVE-BACK SHEET 3/32" THK.)
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
 X.XX = +/- 0.01" / +/- 0.5°
 X.XXX = +/- 0.005" / +/- 0.1°
 X.XXXX = +/- 0.0005" / +/- 0.05°
 PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: N/A

DESIGN	KPT	DART AEROSPACE LTD	
DRAWN	VM	HAWKESBURY, ONTARIO, CANADA	
CHECKED	VM	TOOL PART #	REV B
MFG. APPR.	FK	RBEB290-P0004-101	SHEET 7 OF 9
APPROVED	W.M	TITLE	
		SCALE	
		NTS	
DATE 2019-06-12			
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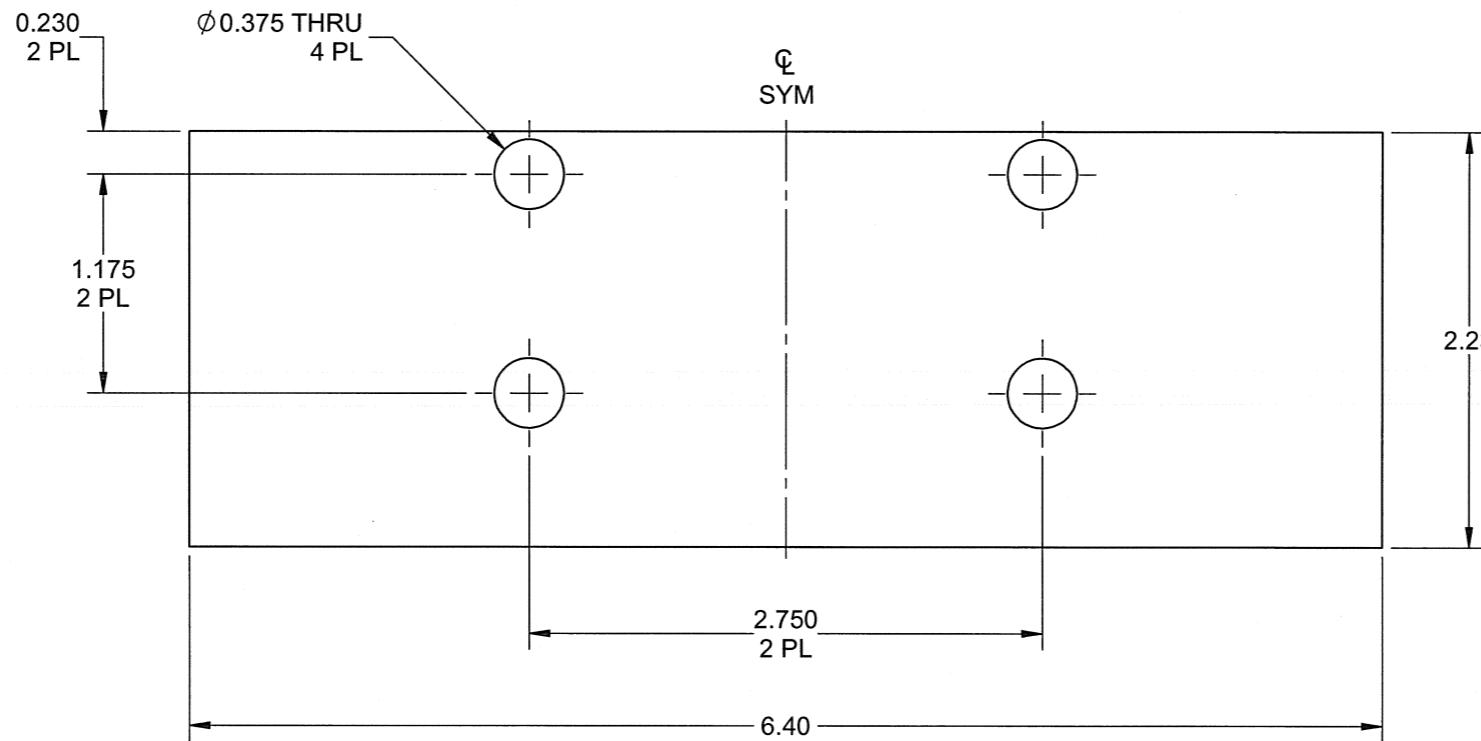
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RBE290-P0004-101-9 BACK PAD

NOTES:

1) MATERIAL: McMaster#8969K654 OR EQUIV. (ULTRA-STRENGTH OIL-RESISTANT BUNA-N RUBBER ADHESIVE-BACK SHEET 3/32" THK.)

2) HEAT TREAT: N/A

3) FINISH: N/A

4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
 X.XX = +/- 0.01" / +/- 0.5°
 X.XXX = +/- 0.005" / +/- 0.1°
 X.XXXX = +/- 0.0005" / +/- 0.05°

PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"

5) UNITS: INCHES UNLESS OTHERWISE NOTED

6) REMOVE ALL SHARP EDGES AND BURRS

7) IDENTIFICATION: N/A

DESIGN DRAWN	KPT VM	DART AEROSPACE LTD	
CHECKED	VM	HAWKESBURY, ONTARIO, CANADA	
MFG. APPR.	FK	TOOL PART #	REV B
APPROVED	WY	RBE290-P0004-101	SHEET 8 OF 9
DATE 2019-06-12		TITLE SCALE	
		ANGLE ASSEMBLY NTS	

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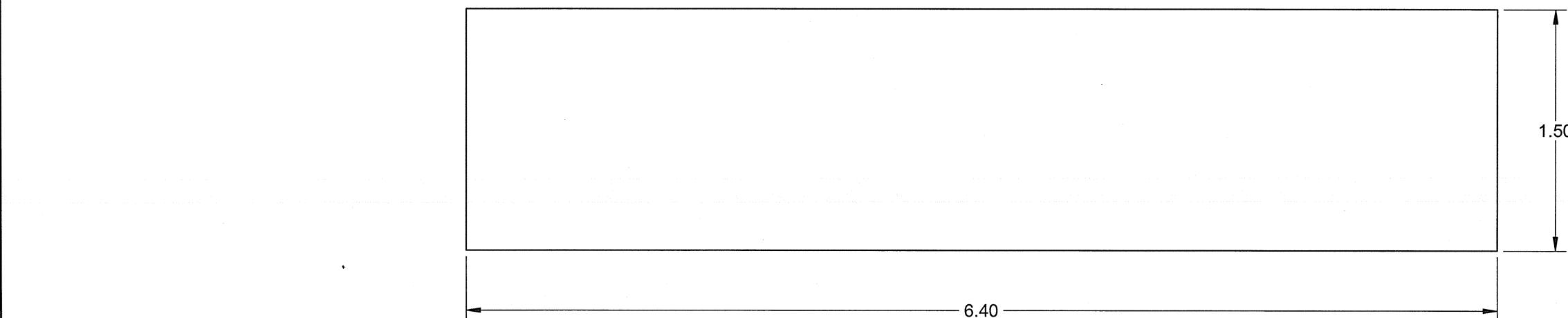
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RBEB290-P0004-101-11 FRONT PAD

NOTES:

- 1) MATERIAL: McMaster#8969K654 OR EQUIV. (ULTRA-STRENGTH OIL-RESISTANT BUNA-N RUBBER ADHESIVE-BACK SHEET 3/32" THK.)
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1°
 X.XX = +/- 0.01" / +/- 0.5°
 X.XXX = +/- 0.005" / +/- 0.1°
 X.XXXX = +/- 0.0005" / +/- 0.05°
 PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) REMOVE ALL SHARP EDGES AND BURRS
- 7) IDENTIFICATION: N/A

DESIGN DRAWN	KPT VM	DART AEROSPACE LTD	
CHECKED	VM	HAWKESBURY, ONTARIO, CANADA	
MFG. APPR.	FK	TOOL PART #	REV B
APPROVED	<i>VM</i>	RBEB290-P0004-101	SHEET 9 OF 9
DATE 2019-06-12		TITLE ANGLE ASSEMBLY	
SCALE NTS			

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